

Work Order ID 68240

Monday, April 11, 2011 8:26:59 AM



Page 1

Item ID: D3202-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Cover

Start Date: 4/11/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 11-04-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3202

Rev D

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3202

Dwg Rev: DProg Rev: D

5052 ,032

2-Deburr if necessary

B11-5-5



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-5

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 u/s/05

④12

130

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12 of 11 u/s/06

140

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:30
OVEN TEMPERATURE: 320 °F
FINISH TIME: 4:00

④12x of 11 u/s/06

M115128

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Cust Item ID:

Required Date: 4/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Run 4/10/9 *(12)*

160

Identify as per dwg & Stock Location: *241A*

0.00



Packaging

Memo

0.00

Packaging

Run 4/10/9 *(12)*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/k A

ME
11-05-09

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Picklist Print

Monday, April 11, 2011 8:27:06 AM

Work Order ID: 68240



Parent Item: D3202-1



Parent Item Name: Cover



Start Date: 4/11/2011

Required Date: 4/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:B No Longuer Made In House 05-11-06 JLM
 IPP Rev:C Now on Waterjet 07-04-18 JLM
 IPP Rev:D chg to revC as per dwg 08-04-21 DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.032		Purchased	No			100	sf	100.0000	1.551	19.59158			
 													
5052-H32 .032 Sheet													

B11-55

Location	Loc Qty	Loc Code
MAT022	100	
100470	2	
103321	2	
105998	3	
108462	5	
109478	6	
111448	2	
112664	16	
115638	12	
116657	52	

116657

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Dart Aerospace Ltd

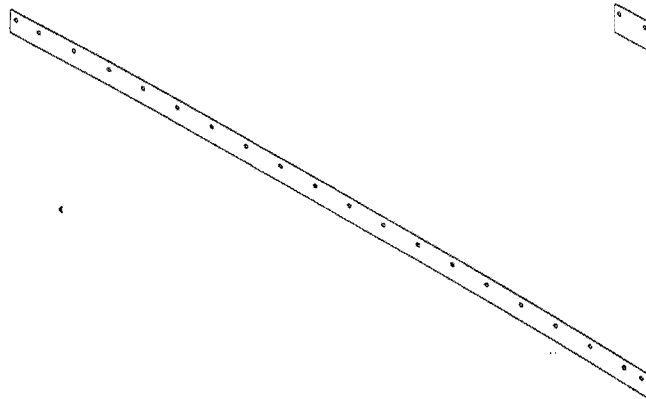
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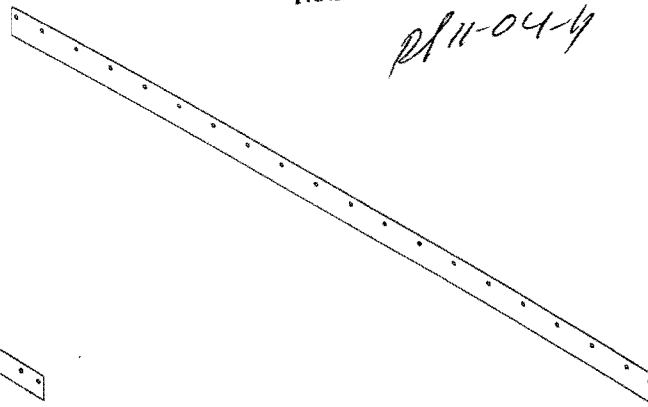
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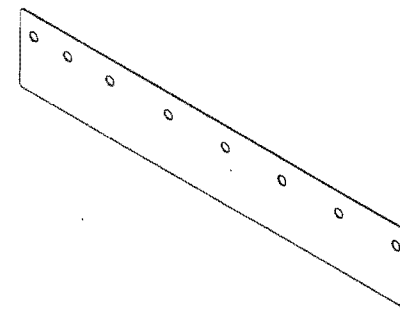
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 68240
plh-04-4



D3202-1 COVER



D3202-3 COVER
 (COMPOSITE DOOR)



D3202-5 COVER
 (HINGE PANEL DOOR MOD)

RELEASED
11-10-11

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.032 THICK
 PER AMS-QQ-A-250/8 OR AMS 4016
 REF. DART SPEC M5052H32S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.56 lbs APPROX FOR -1
 : 0.61 lbs APPROX FOR -3
 : 0.18 lbs APPROX FOR -5

D	ADD -5 FOR HINGE PANEL DOOR MOD.	AJS	08.11.03
C	ADD -3 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD. INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION)	AJS	08.03.31
B	RE-DESIGN PART NOW CURVED	CP	03.10.16
A	NEW ISSUE	CP	01.01.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3202	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

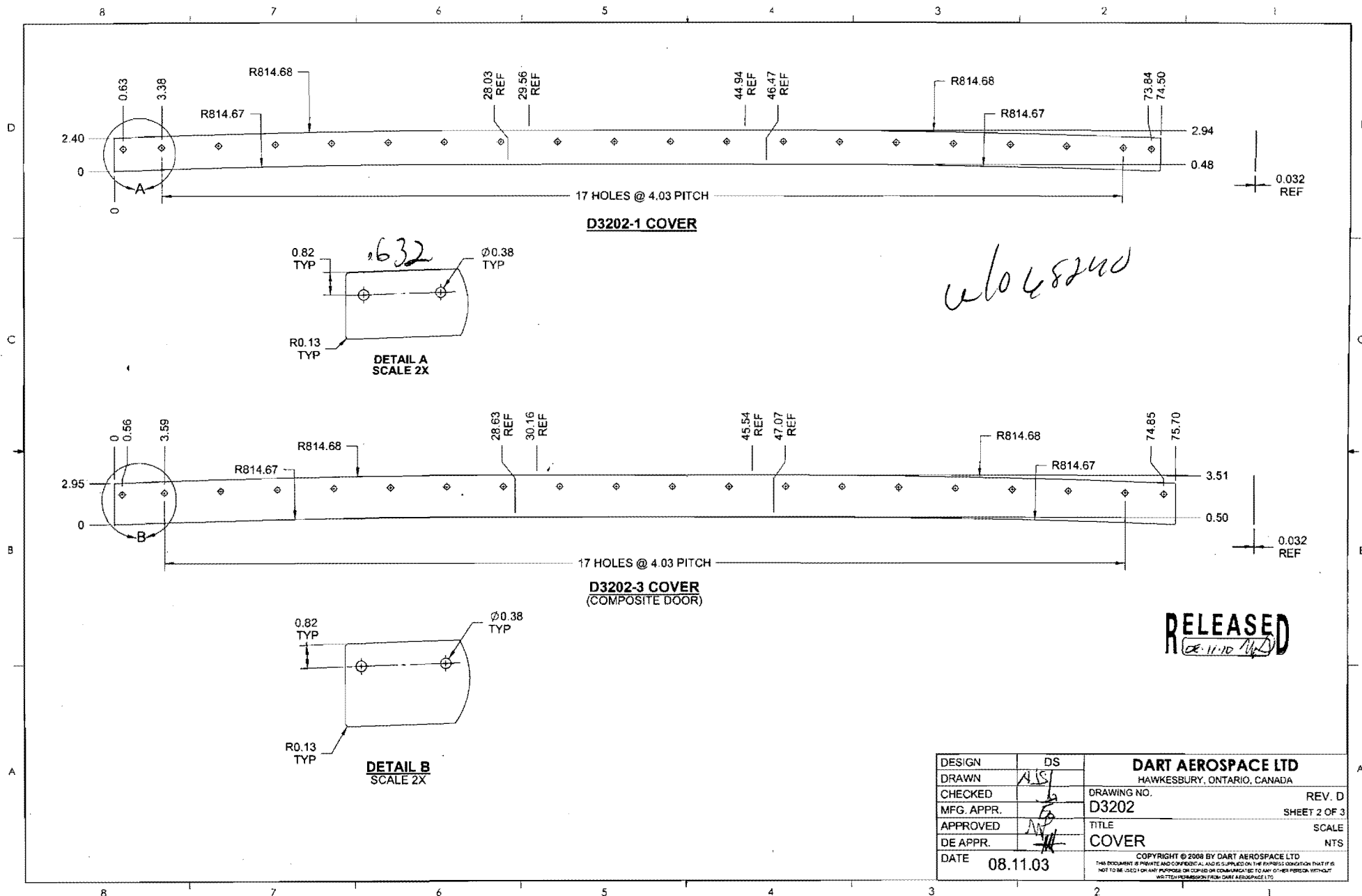
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DRAWN	ALST	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. D
MFG. APPR.	h	D3202	SHEET 2 OF 3
APPROVED	h	TITLE	SCALE
DE APPR.	h	COVER	NTS
DATE	08.11.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

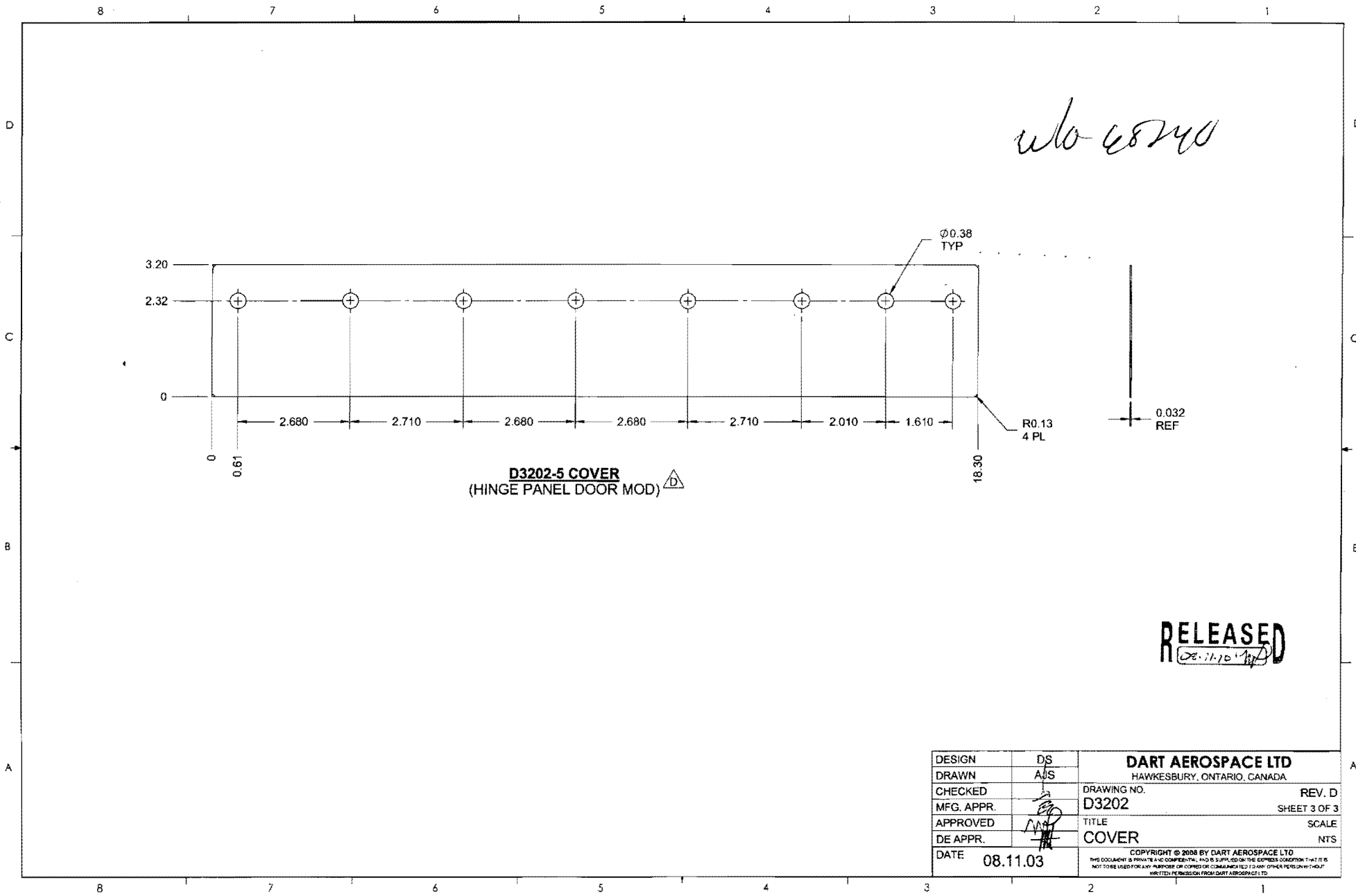
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